

Work Order ID 81670

March-16-12 1:57:03 PM

Ship March 22

81670

Page 1

Item ID: D407-802-017

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Passenger Door Opener Installation, LH

Start Date: 16/03/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MCS Date: 12/03/12 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D407-802-1	A

100 DOCUMENT CONTROL sl 0.00

100

DC Memo 0.00

Document Control Photocopy bluefile and create labels per PPP D407-802-017 CHG001

S. Schultz

MCS 12/03/20

105 Pick Kit 0.00

105

Packaging Memo 0.00

Packaging

12/3/12

110 QC4- 100% Inspect kits for completeness 0.00

110

QC Memo 0.00

Quality Control

S. Schultz

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81670***81670***

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Item ID: D407-802-017

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Passenger Door Opener Installation, LH

Start Date: 16/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD407-802-017								
	Location: <u>11</u>								
	PPP rev: <u>A</u>								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

M15 12/04/27

12-04-27

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 81670

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Parent Item: D407-802-017

D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC
10.12.03 as per dwg rev.A DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-17

Manufactured No

105

Each

15.0000

1

1

D3552-17

Door Prop

**

Location

Loc Qty

Loc Code

ST272

5

64338

4

65120

1

ST276

10

69670

10

D3622-5

Manufactured No

105

Each

24.0000

1

D3622-5

Ball Stud

**

Location

Loc Qty

Loc Code

ST058

24

76963

4

80406

20

D4108-1

Manufactured No

105

Each

8.0000

1

D4108-1

Door Doubler, Left

**

Location

Loc Qty

Loc Code

st128

8

64484

1

79343

7

D4108-049

Manufactured No

105

Each

0.0000

1

D4108-049

Litter Door Fitting Assembly

**

383780

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D407-802-017

D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

CR3523-4-03

Purchased

No

105

Each

174.0000

21

CR3523-4-03

RIVET

**

Location

Loc Qty

Loc Code

ST331

146

120187

46

120521

100

ST332

28

112991

10

116373

18

MS20426AD4-5

Purchased

No

105

Each

5,032.000

2

MS20426AD4-5

Rivet

**

Location

Loc Qty

Loc Code

ST317

5032

6874

5032

MS21073L5

Purchased

No

105

Each

38.0000

1

MS21073L5

nut plate

**

Location

Loc Qty

Loc Code

ST302

28

117395

28

ST303

10

120986

10

MS21209F1-15

Purchased

No

105

Each

8.0000

3

MS21209F1-15

HELI COIL

**

Location

Loc Qty

Loc Code

ST305

8

120308

8

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Shop Packet Print

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Parent Item: D407-802-017

D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-06

Purchased

No

105

Each

38.0000

3

MS27039C1-06

Screw

**

Location

Loc Qty

Loc Code

ST293

38

115768

38

105

Each

124.0000

1

MS27039C1-09

Purchased

No

MS27039C1-09

SCREW

**

Location

Loc Qty

Loc Code

FP002

28

17831

28

ST293

96

116290

96

105

Each

19.0000

2

MS27039C1-27

Purchased

No

MS27039C1-27

Screw

**

Location

Loc Qty

Loc Code

ST293

19

115768

19

105

Each

3,127.000

2

NAS1149C0332R

Purchased

No

NAS1149C0332R

Washer

**

Location

Loc Qty

Loc Code

ST297

3127

118354

491

119736

196

120648

2440

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D407-802-017

D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C1165R

Purchased

No

105

Each

69.0000

2

2

NAS1149C1165R

Washer

**

Location

Loc Qty

Loc Code

ST296

69

115768

69

105

Each

485.0000

6

NAS1149C0532R

Purchased

No

NAS1149C0532R

WASHER

**

Location

Loc Qty

Loc Code

ST297

485

116373

1

116513

53

118384

31

119736

400

105

Each

422.0000

6

NAS1149C0563R

Purchased

No

NAS1149C0563R

Washer

**

Location

Loc Qty

Loc Code

ST296

200

120422

200

ST297

222

116391

22

117460

200

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

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5.3 D407-802-017/-018 Passenger Door Opener Kits

Qty -017	Qty -018	Part Number	Description
		D407-802-017	PASSENGER DOOR OPENER KIT, LH
		D407-802-018	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	1	D3622-5	BALL STUD
1		D4108-1	DOOR DOUBLER, LEFT
	1	D4108-3	DOOR DOUBLER, RIGHT
	1	D4108-5	SMALL RIGHT DOOR DOUBLER
	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
1		D4108-049	LITTER DOOR FITTING ASSEMBLY
	19	CR3523-4-2	RIVET
21		CR3523-4-3	RIVET
	4	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
	2	MS20426AD4-6	RIVET
1	1	MS21073L5	ANCHOR NUT
3		MS21209-F1-15	HELICOIL
3		MS27039C1-06	SCREW
1		MS27039C1-09	SCREW
2	2	MS27039C1-27	SCREW
2	2	NAS1149C0332R	WASHER
2	2	NAS1149C1165R	WASHER
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.4 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT

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Revision: A
Date: 10.10.13